

W/S

(5491)



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**RBBP1425-103-03**  
**Job Sheet 179038**



Part No: RBBP1425-103-03

Job Qty: 8 ea

Part Name: Keeper



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 6/12/18

Job Tracking No:

Due Date: 7/30/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBBP1425-101 Rev D IPP Rev A 18.03.13 New issue DP Verify DD/DWG RBBP1425-101 Rev D IPP Rev B 18.04.04 DWG update DP Verify DD

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 8 Ea  | 7/30/18    | 7/30/18  | 0.00      | 0.00    | Start Up Machining-3  |           | 18/07/25 |
| 100   | Waterjet           | 8 pcs | 7/30/18    | 7/30/18  | 0.00      | 0.80    | Waterjet 2 OMAX       |           | 18/07/25 |
| 110   | Mori Seiki         | 8 pcs | 7/30/18    | 7/30/18  | 0.00      | 4.00    | MORI SL2500Y          |           | 18/07/25 |
| 120   | QC                 | 8 pcs | 7/30/18    | 7/30/18  | 0.00      | 0.00    | QC2 Machining-4       |           | 18/07/25 |
| 130   | Mori Seiki         | 8 pcs | 7/30/18    | 7/30/18  | 0.00      | 2.00    | MORI NV5000-1         |           | 18/07/25 |
| 140   | QC                 | 8 pcs | 7/30/18    | 7/30/18  | 0.00      | 0.00    | QC2 Machining-4       |           | 18/07/25 |
| 150   | QC                 | 8 pcs | 7/30/18    | 7/30/18  | 0.00      | 0.00    | QC8 Machining-4       |           | 18/07/25 |
| 180   | Outsource          | 8 pcs | 7/30/18    | 7/30/18  | 0.00      | 0.00    | Outsource12           |           | 18/07/25 |
| 200   | Packaging          | 8 pcs | 7/30/18    | 7/30/18  | 0.00      | 0.00    | Packaging2            |           | 18/07/25 |
| 210   | QC                 | 8 pcs | 7/30/18    | 7/30/18  | 0.00      | 0.00    | QC6                   |           | 18/07/25 |
| 215   | Packaging          | 8 pcs | 7/30/18    | 7/30/18  | 0.00      | 0.00    | Packaging3            |           | 18/07/25 |
| 220   | QC21-SA            | 8 Ea  | 7/30/18    | 7/30/18  | 0.00      | 0.00    | QC21                  |           | 18/07/25 |

Part Op 100 - 1-Cut blanks (RED BARN FOLDER) \*\*\*Note\*\*\*makes four pieces\*\*\*

Descriptions: 110 - 1-Machine as per folio FC025 FOLIO REV: \_\_\_\_\_ DWG REV: \_\_\_\_\_ 2-Debur  
130 - 1-Machine as per folio FC025 FOLIO REV: \_\_\_\_\_ DWG REV: \_\_\_\_\_ \*\*\*Note\*\*\*makes four pieces\*\*\* 2-Debur 3-Machine engrave as per note 6  
180 - -Issue P/O to Groupe Altech; PO040677 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

## Job BOM

| Part / Item            | Component Name              | Quantity          | Operation             | Container |
|------------------------|-----------------------------|-------------------|-----------------------|-----------|
| MT-4140-S-0.500X10.000 | AISI 4140 Steel Sheet/Plate | 4.8000 ft (.6 ea) | 90-Start up Operation |           |

## Job Allocations

| Operation             | Component Part         | Required | Inventory | Allocated |
|-----------------------|------------------------|----------|-----------|-----------|
| 90-Start up Operation | MT-4140-S-0.500X10.000 | 5        | 16        | 0         |

## Part Specifications

Specifications could not be found.

Plex 7/24/18 5:10 PM dart.logan.david



Container No: S096382

Part: RBBP1425-103-03

Job No: 179038

Serial No/Batch: S096382

Revision: D

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Date: 07/25/10





DQA: \_\_\_\_\_ Date: \_\_\_\_\_



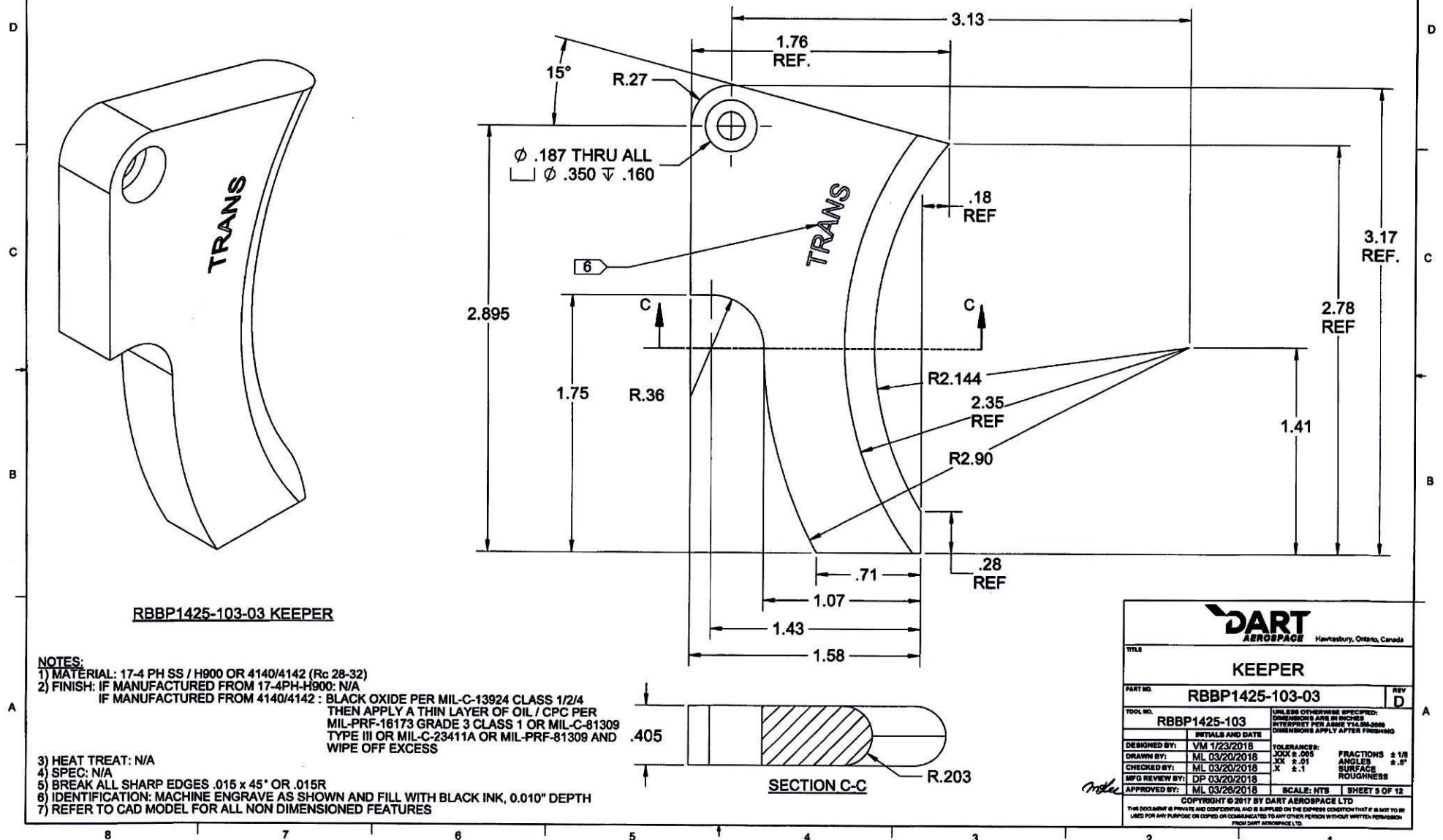
## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                       |  |
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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>             Skid-tube <input type="checkbox"/><br/>             Machining <input type="checkbox"/><br/>             Thermoforming <input type="checkbox"/><br/>             Large Fab <input type="checkbox"/> </div> <div>             Cross tube <input type="checkbox"/><br/>             Small Fab <input type="checkbox"/><br/>             Finishing <input type="checkbox"/><br/>             Composite <input type="checkbox"/> </div> <div>             Water Jet <input type="checkbox"/><br/>             Prod. Eng. Coord. <input type="checkbox"/><br/>             Rec/Store/Packaging <input type="checkbox"/><br/>             Supplier <input type="checkbox"/> </div> <div>             Engineering <input type="checkbox"/><br/>             Quality <input type="checkbox"/><br/>             Other <input type="checkbox"/> </div> </div> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                       |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Step #:                                                                                                                                                                            | QTY Effective :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | MRB (QSI042) Approval |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                       |  |
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| <b>Root Cause</b><br><div style="display: flex; justify-content: space-between;"> <div>             Environment <input type="checkbox"/><br/>             Design <input type="checkbox"/><br/>             Doc/Data <input type="checkbox"/><br/>             Equip/Tooling <input type="checkbox"/><br/>             Handling/Pre <input type="checkbox"/><br/>             Material <input type="checkbox"/><br/>             Internal Transport <input type="checkbox"/><br/>             Tribal Knowledge <input type="checkbox"/><br/>             LOA <input type="checkbox"/><br/>             Substation <input type="checkbox"/><br/>             Past Expiry Date <input type="checkbox"/><br/>             Misidentified <input type="checkbox"/> </div> <div>             No Re-verification <input type="checkbox"/><br/>             Operator <input type="checkbox"/><br/>             Offset/Setup <input type="checkbox"/><br/>             Supplier <input type="checkbox"/><br/>             Training <input type="checkbox"/><br/>             Use for Testing <input type="checkbox"/><br/>             Poor Information <input type="checkbox"/><br/>             Rushing <input type="checkbox"/><br/>             Product Improvement <input type="checkbox"/><br/>             Process Improvement <input type="checkbox"/><br/>             Manufacturing Process <input type="checkbox"/><br/>             Past Due <input type="checkbox"/> </div> </div> |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | <b>FAULT CATEGORY</b><br><div style="display: flex; justify-content: space-between;"> <div>             Pressure/Forced <input type="checkbox"/><br/>             Bending <input type="checkbox"/><br/>             Centre Not Concentric <input type="checkbox"/><br/>             Cracks <input type="checkbox"/><br/>             Crimp/Kink/Ripple/Wave <input type="checkbox"/><br/>             Cuffs <input type="checkbox"/><br/>             Crushing <input type="checkbox"/><br/>             Heat Treat <input type="checkbox"/><br/>             Wave/Twist in Tube <input type="checkbox"/><br/>             Marks/Chatter <input type="checkbox"/> </div> <div>             Temperature/Cure <input type="checkbox"/><br/>             Set-up <input type="checkbox"/><br/>             BOM/Route <input type="checkbox"/><br/>             Broken/Damage/Defect <input type="checkbox"/><br/>             Inspection Incomplete/Unqualified <input type="checkbox"/><br/>             Contamination <input type="checkbox"/><br/>             Countersink <input type="checkbox"/><br/>             Cut Too Short <input type="checkbox"/><br/>             Instructions Incomplete/Unclear <input type="checkbox"/><br/>             Drill Holes <input type="checkbox"/> </div> <div>             Power Loss/Surge <input type="checkbox"/><br/>             Folio/Program <input type="checkbox"/><br/>             Grain <input type="checkbox"/><br/>             Weld <input type="checkbox"/><br/>             Wrong Stock Pulled <input type="checkbox"/><br/>             Out of Sequence <input type="checkbox"/><br/>             Off-set <input type="checkbox"/><br/>             Misabeled <input type="checkbox"/><br/>             Fit/Function <input type="checkbox"/><br/>             Misaligned/off center <input type="checkbox"/> </div> <div>             Positioned Wrong <input type="checkbox"/><br/>             Outside Dimensions <input type="checkbox"/><br/>             Over/Under tolerance <input type="checkbox"/><br/>             Part Incorrect <input type="checkbox"/><br/>             Part Lost/Missing <input type="checkbox"/><br/>             Part Moved <input type="checkbox"/><br/>             Drawing <input type="checkbox"/><br/>             Finish <input type="checkbox"/><br/>             Misread <input type="checkbox"/><br/>             Turning Sequence <input type="checkbox"/> </div> </div> |                       |  |
| OTHER : <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                       |  |

| REV. | DESCRIPTION                                                                                                              | ECN #  | DATE    | BY | APPROVED |
|------|--------------------------------------------------------------------------------------------------------------------------|--------|---------|----|----------|
| C    | TEMPLATE UPDATED, MATERIAL 4140/4142 CHANGED FOR 17-4 PH / H900, FINISH REMOVED, VIEWS CHANGED FOR CLARITY, NOTE 7 ADDED | 17-647 | 18.1.23 | VM | ML       |





Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# **PURCHASE ORDER** **PO040677**

**Supplier:** GRO002-VC  
Group Altech  
2455 Halpern  
St Laurent  
QC  
H4S 1N9 Canada  
Phone: 514-335-3666  
Fax: 514-335-3868

**PO No:** PO040677  
**PO Date:** 8/2/18  
**Due Date:** 8/8/18  
**Purchase Order**  
**Revision:**  
**Revision Date:**  
**Ship-To Contact:** Tsimiklis, ChrisoulaPhone:

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Via:** Ground  
**Pynt Terms:** Net 30  
**Freight Terms:**  
**Special Comments:**

## **Items**

| Line Item         | Job    | Part            | Description                                                                                                                         | Status | Account | Due Date | Order Quantity | Received Quantity | Balance   | Unit Price (CAD) | Extended Price  |
|-------------------|--------|-----------------|-------------------------------------------------------------------------------------------------------------------------------------|--------|---------|----------|----------------|-------------------|-----------|------------------|-----------------|
| 1                 | 179038 | RBBP1425-103-03 | Keeper<br>-Issue P/O to Groupe Altech;<br>PO<br>-Black oxide finish, MIL-C-13924C Class 1<br>-Certificate of Conformity is required | Firmed | -       | 8/8/18   | 8 pcs          | 0 pcs             | 8 pcs     | \$6.00/pcs       | \$48.00         |
|                   | 175856 |                 |                                                                                                                                     | Firmed | -       | 8/8/18   | 12 pcs         | 0 pcs             | 12 pcs    | \$6.00/pcs       | \$72.00         |
| <b>Sub Total:</b> |        |                 |                                                                                                                                     |        |         |          | <b>20</b>      | <b>0</b>          | <b>20</b> |                  | <b>\$120.00</b> |

|   |        |        |                                                                                                                                                                                                      |        |   |        |        |       |        |             |          |
|---|--------|--------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---|--------|--------|-------|--------|-------------|----------|
| 2 | 177764 | C10-23 | Keeper Weldment<br>-Issue P/O to GROUPE ALTECH: P/O<br>-Nickel plate, QQ-N-290, Class 2, Grade E or F<br>-Nickel Plate .0004- .0006<br>-Bake after plating<br>-Certificate of Conformity is required | Firmed | - | 8/8/18 | 10 pcs | 0 pcs | 10 pcs | \$24.00/pcs | \$240.00 |
|---|--------|--------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---|--------|--------|-------|--------|-------------|----------|

**Grand Total:** \$360.00

## **Order Notes**

CT

DAS  
38  
9-89



**Order Notes****Procurement Quality Clauses**

A005 right of entry  
A012 chemical and physical test report  
A016 personnel qualification  
A017 raw material identification (as applicable)

A022 Apical Processing  
A024 process certifications  
A026 certification of material conformance

A041 quality management system  
A042 dart notification by supplier  
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

Plex 8/3/18 11:38 AM dart.tsimiklis.chrisoula



## Certificat de Conformité / Certificate of Compliance

(011515-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9  
 Tel: 514-335-3666 Fax: 514-335-3868  
 www.groupaltech.com

## Bon de Livraison / Packing Slip

011515- 1

Livré à / Ship to

**DART AEROSPACE LTD**  
 1270 ABERDEEN STREET  
 HAWKESBURY, ON, K6A1K7  
 CANADA  
 Tel.: 613-632-5200 Fax.:

Client / Customer:

**DART AEROSPACE LTD**  
 1270 ABERDEEN STREET  
 HAWKESBURY, ON, K6A1K7  
 CANADA  
 BUYER:

| Date expédition<br>Ship date |                                                                            | Créé Par<br>Generated By                                                                                              | Transport / No de Compte<br>Courier / Acc. No. | Bon de commande Client<br>Customer Purchase Order No. |                 |                   |               |                        |
|------------------------------|----------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------|------------------------------------------------|-------------------------------------------------------|-----------------|-------------------|---------------|------------------------|
| 07-Aug-2018                  |                                                                            | Aman                                                                                                                  |                                                | 040677                                                |                 |                   |               |                        |
| #Ligne<br>Line#              | No. de Série / # Pièce<br>Part Number / Line Item Details<br>Job # / Ref # | Description pièce(s)                                                                                                  | CATG.<br>U/M                                   | Comm.<br>/Ordered                                     | Exp/<br>Shipped | Qté NC/<br>NC Qty | Qté<br>Scrap/ | À venir/<br>Back Order |
| 1                            | RBBP1425-103-03,<br>Rev.                                                   | RBBP1425-103-03<br>01-OXIDE BLACK [OXIDE BLACK]<br>MIL-C-13924C CLASS1                                                | OXIDE-BLACK<br>CH                              | 20 ✓                                                  | 20              | 0                 | 0             | 0                      |
| 2                            | C-10-23 ✓<br>Rev.                                                          | C-10-23<br>01-E-NIC STEEL 200 [E-NICKEL STEEL 200]<br>QQ-N-290<br>CLASS2 GRADE E OR F<br>0.0004 TO 0.0006<br>AND BAKE | E-NICKEL-200<br>CH                             | 10 ✓                                                  | 10              | 0                 | 0             | 0                      |

Notes Additionnelles / Additional Notes

Epaisseur réelle  
Actual Thickness

Inspecteur Qualité  
Quality Inspector

Réçu par  
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.  
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.  
 Our financial and legal responsibility will not be higher than the amount of invoice.